

**Work Order ID 70411**

Tuesday, June 07, 2011 1:30:54 PM



ASAP

Page 1

Item ID: D3809-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Sliding Block

Start Date: 6/7/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 6/8/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-06-07

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3809

Rev A

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut Blanks 1.850" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

WATER SET

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA770 Rev: A & Dwg D3809 Rev: A □2-Deburr  
per dwg D3809

11/06/08

B11-6-7

9



120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/06/08

B11-6-7



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Item Name: Sliding Block

Start Date: 6/7/2011 Start Qty: 4.00



Cust Item ID:

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Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00							
140  Packaging Packaging	Identify as per dwg & Stock Location: <i>84</i>  Memo	0.00  0.00							
150  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							

*11/6/8**11/6/88**11/6/98**MF 11-06-08*

# Picklist Print

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Page 1

Work Order ID: 70411



Parent Item: D3809-1



Parent Item Name: Sliding Block

Start Date: 6/7/2011

Required Date: 6/8/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A nEW iSSUE 08-08-01 JLM Verified By:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINB0.250X01.0 00		Purchased	No			100	f	6.0000	0.15	0.631579			



Delrin Bar 0.25" x 1.0"



B 11-6-7

1125 x 3.

Location

MAT055

110877

110115

Loc Qty

6

6

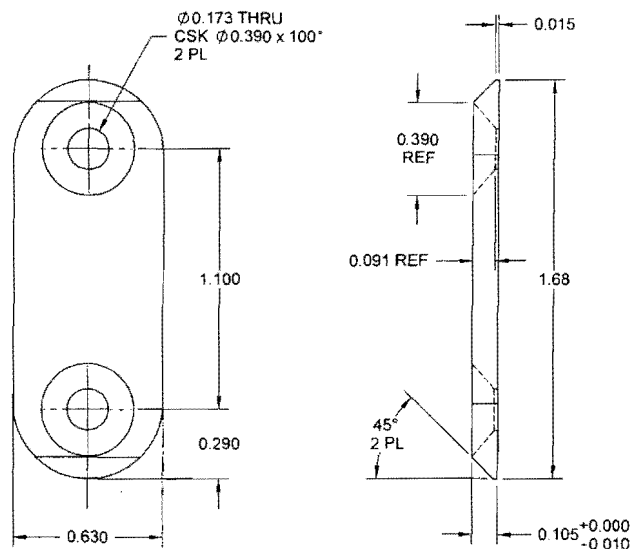
Loc Code

110115

9

MDEL RIN 50.125 x 30.0





**D3809-1 SLIDING BLOCK**  
**SCALE 2X**

**NOTES:**

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL SHEET OR BAR (REF. DART SPEC. M-DELRIN-S OR M-DELRIN-B)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.004 lbs

**RELEASED**  
08-07-24/118

A	NEW ISSUE	RF	08.07.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	D3809	SHEET 1 OF 1
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SLIDING BLOCK	NTS
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